

Work Order ID 65949

Thursday, January 27, 2011 2:34:19 PM

shp 28/01

PRELIMINARY ISSUE

Page 1

Item ID: D4072-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Airframe Hinge

Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4072

A U/R

MP 11/01/31

100

Cut blanks as per folio

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 1.250" LONG

105

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA938

Dwg Rev:

Folio Rev:

Manual Mill
Deburr

11/01/27

2

11/04/28

2

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Run Start

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sanding (Ref: 4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

170

QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

180

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

Packaging

POSITIVE RECALL

EFFECTIVE

AUTH

LEASED

DATE

MF
11-01-28

2 BK 11-01-28.
11/28
PTD →
11/28

White
M 112588
START 8:45
OVER 330°
FINISH 9:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4072-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ ^{Prelim - U/R} DQA: / Date: 11.02.07

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>65947</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11.01.28</u>	<u>160</u>	<u>strip and re powder coat white - Route is incorrect s/p white</u>	<u>W</u> <u>11.01.28</u>	<u>M 115951.</u> <u>START 10:45</u> <u>AVANT. 300°</u> <u>FINISH 11:15</u>	<u>BL</u> <u>11-01-28</u>	<u>S</u> <u>11/4/31</u>	<u>LE</u> <u>11.01.28</u>	<u>S</u> <u>11/4/31</u>

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Thursday, January 27, 2011 2:34:16 PM

T

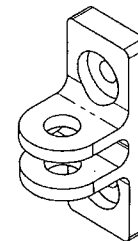
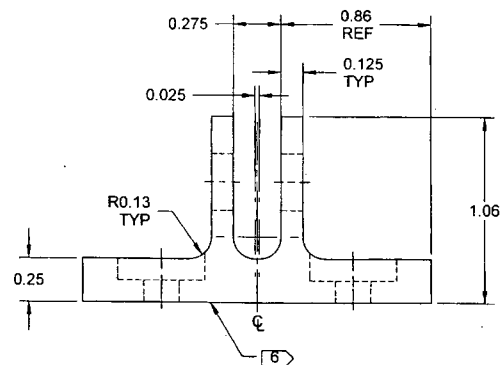
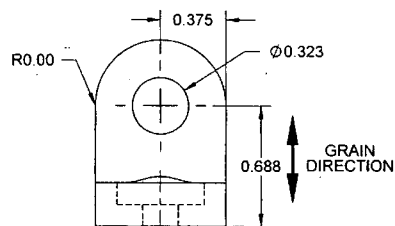
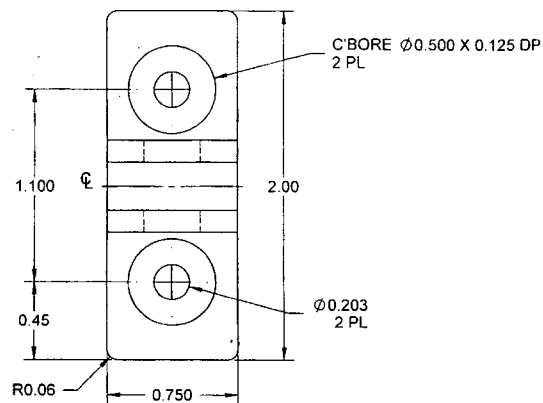
Parent Item Name: Airframe Hinge

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50 0		Purchased				100	f	35.3600	0.104	0.218947			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	20	
114993	20	
MAT03	15.36	
103019	7.53	
103039	7.83	

.22 D 11/01/27



D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

11/10/13

UNDER REVIEW

RELEASED

2010-09-22

A NEW ISSUE		RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	140		
MFG. APPR.	21		
APPROVED	140		
DE APPR.	21		
DATE	10.09.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4072**

TITLE **AIRFRAME HINGE**

REV. A
SHEET 1 OF 3
SCALE
NTS

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